

Work Order ID 51327

Page 1

August 19, 2009 10:49:13 AM

Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 09-08-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2917	Rev B
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100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Program batch number □ Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet □ Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet □ Machine Step No 3 as per Folio

110



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

Conventional Milling Machine

0.00

ark 09/09/08

0.00

*4 8**4 8*

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

ark 09/09/08

0.00

4 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
Code

Qty

Accept
Qty

Qty

Reject
Qty

Number

Reject
Number

Stamp

0.00

510909/09

4

6

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BK0909-9

(H)

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BK09-09-9

(A)

0.00

Memo 9:15
START TIME: 3200 FINISH TIME: 9:45
OVEN TEMPERATURE:

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Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

→ 09/09/09



QC

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

MF 09-09-09

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Picklist Print

Page 1

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Work Order ID: 51327



Parent Item: D2917-1RevB



Parent Item Name: Saddle LH

Start Date: 08/19/2009

Required Date: 08/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured		No		100	Each	0.0000	4.0000			

Saddle Billet

Batch #: 51423

awf 09/09/08

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD			Work Order:	51327
Description: Saddle LH			Part Number:	D2917-1
Inspection Dwg: D2917 Rev. A1			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.184	.196	.190	.190		
B	0.090	0.110		.090	.094	.094	.090		
C	0.250	0.270		.266	.263	.263	.261		
D	1.599	1.619		1.618	1.610	1.610	1.610		
E	0.180	0.220		.186	.186	.180	.180		
F	0.277	0.297		.280	.280	.281	.281		
G	1.385	1.400		1.388	1.392	1.390	1.390		
H	3.170	3.230		3.195	3.198	3.200	3.200		
I	0.175	0.217		.186	.180	.177	.179		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.504	1.502	1.503	1.506		
L	4.436	4.446		4.442	4.436	4.436	4.442		
M	0.257	0.262	DT8683	.259	.260	.260	.260		
N	1.225	1.235		1.234	1.229	1.226	1.230		
O	1.103	1.113		1.104	1.106	1.109	1.107		
P	0.470	0.530		.502	.500	.500	.500		
Q	0.438	0.443	DT8682	.442	.441	.441	.441		
R	0.490	0.510		.502	.507	.506	.505		
S	1.745	1.755		1.750	1.750	1.750	1.749		
T	7.990	8.010		8.003	8.004	8.004	8.004		
U	3.495	3.505		3.498	3.500	3.500	3.499		
V	0.175	0.205		.205	.205	.205	.205		
W	1.990	2.010		2.002	2.003	2.002	2.002		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.312	.312	.311	.311		
Z	0.615	0.635		.627	.630	.628	.628		
AA	0.177	0.197		.188	.188	.188	.188		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	John	<i>John</i>	Audited by:	John	<i>John</i>
Date:	09/09/08	09/09/08	Date:	09/09/08	09/09/08

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>John</i>	<i>John</i>

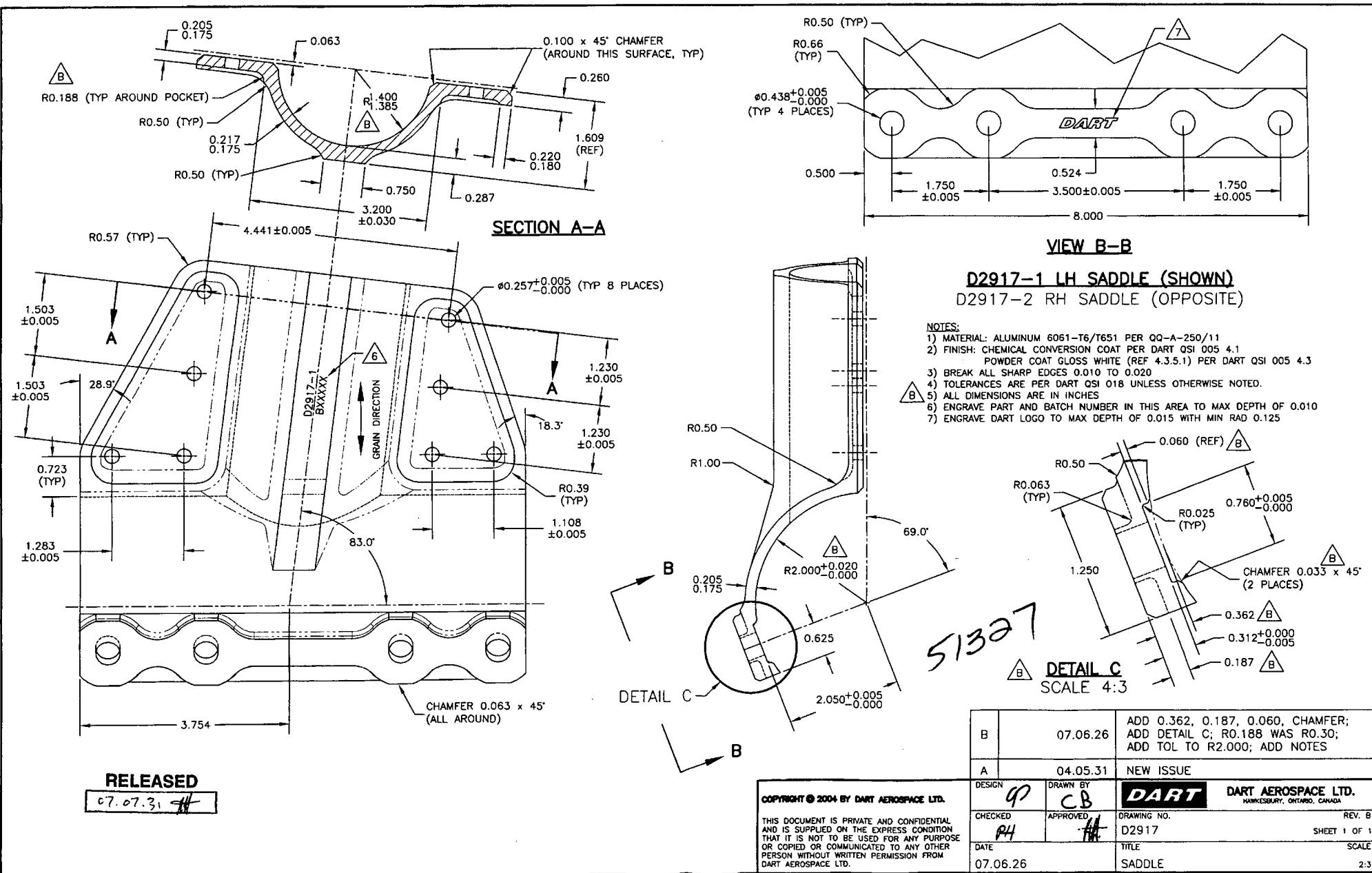
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